

Work Order ID 54690

December 16, 2009 10:50:09 AM



Page 1

Item ID: D3891-4

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 12/16/09 Start Qty: 1.00



Cust Item ID:

Required Date: 12/18/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *PJ*

Date: *09/12/16*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3891	A

100

0.00



Waterjet

Memo

0.00

B 9-12-16

FLOW CNC Waterjet

1-Cut as per Dwg D3891

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

B 9-12-16

(1)

Work Order ID 54690

December 16, 2009 10:50:10 AM



Page 2

Item ID: D3891-4

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 12/16/09 Start Qty: 1.00



Cust Item ID:

Required Date: 12/18/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

→ 50212/16

0.00



QC

Memo

Quality Control

130

Identify as per dwg & Stock Location. G-A

0.00

8 09/12/17



Packaging

Memo

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

A 10.01-06
10.02.5.
B/09-12-18
①

Picklist Print

Page 1

December 16, 2009 10:50:08 AM

Work Order ID: 54690



Parent Item: D3891-4



Parent Item Name: Gasket

Start Date: 12/16/09

Required Date: 12/18/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M411INS.125		Purchased		No		100	sf	322.3414	3.1189		12-16	

4111 Black Neoprene/EPDM/SBR Blend Sheet 0.125"



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

322.3414

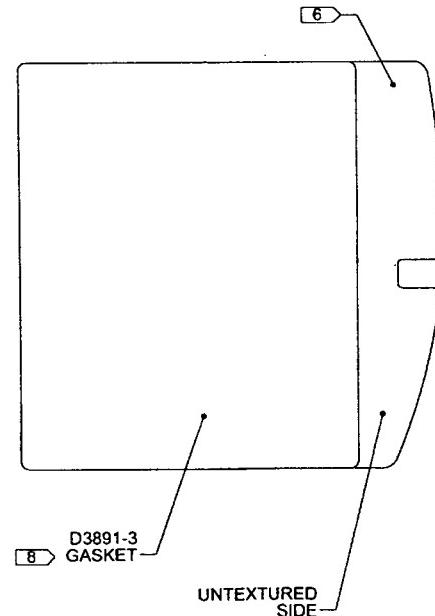
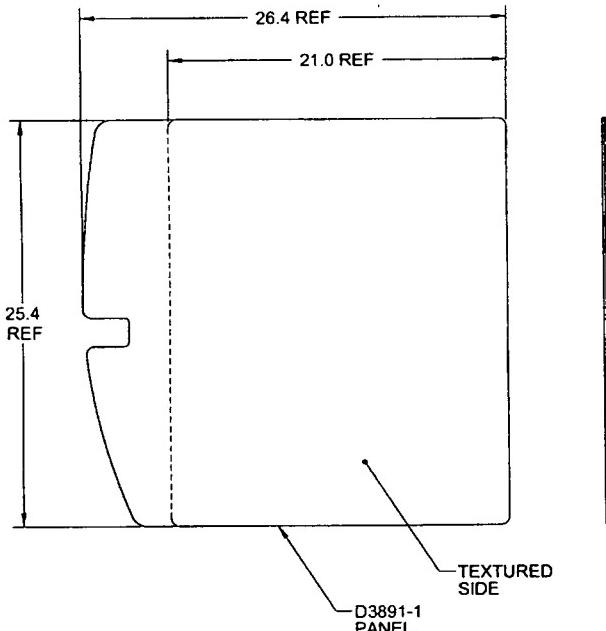
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112335

(1)

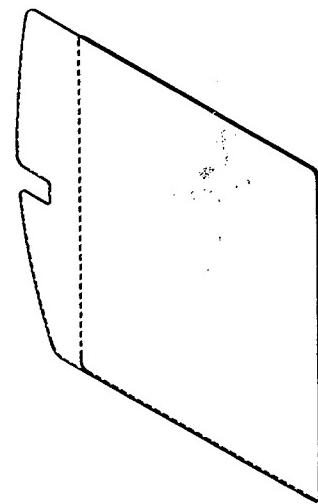
PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3891-041	PANEL, FWD LH
2	1	D3891-1	PANEL
3	1	D3891-3	GASKET
4	A/R	3M 1300	ADHESIVE

D3891-041 PANEL, FWD LH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3891-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 3.67 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54690
pt 09-12-16

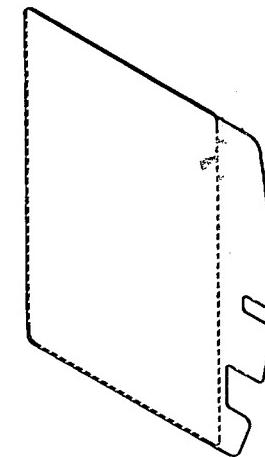
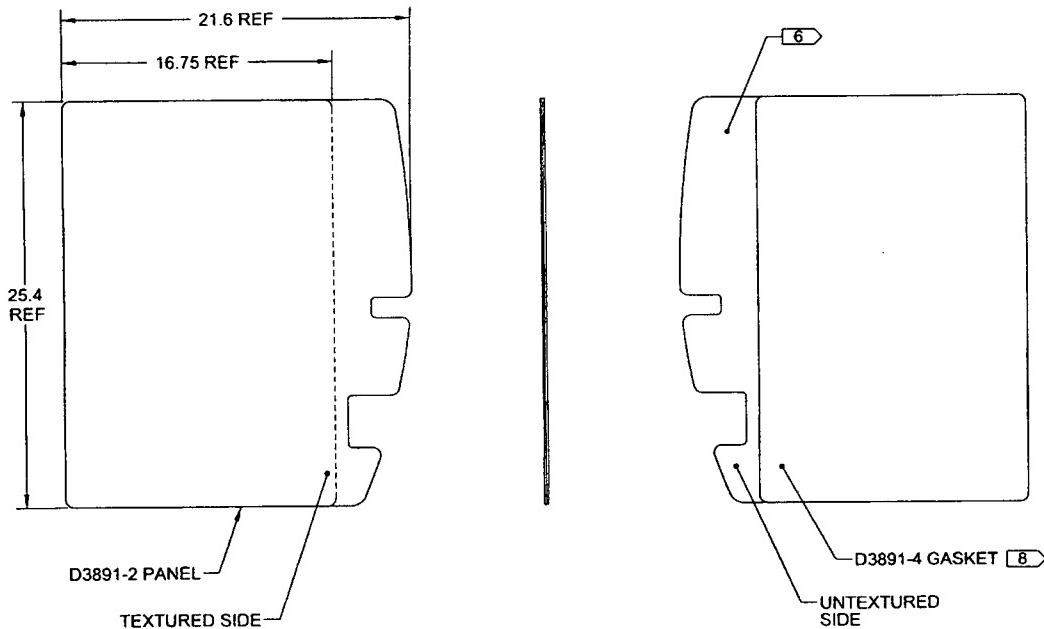
RELEASED
C7/06/16 M

A	NEW ISSUE	CP	09.05.01
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>RP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>RP</i>	REV. A	
CHECKED	<i>RP</i>	SHEET 1 OF 6	
MFG. APPR.	<i>RP</i>	D3891	
APPROVED	<i>RP</i>	TITLE	
DE APPR.	<i>RP</i>	SCALE	
DATE	09.05.01	NTS	

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PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3891-042	PANEL, FWD RH
2	1	D3891-2	PANEL
3	1	D3891-4	GASKET
4	A/R	3M 1300	ADHESIVE



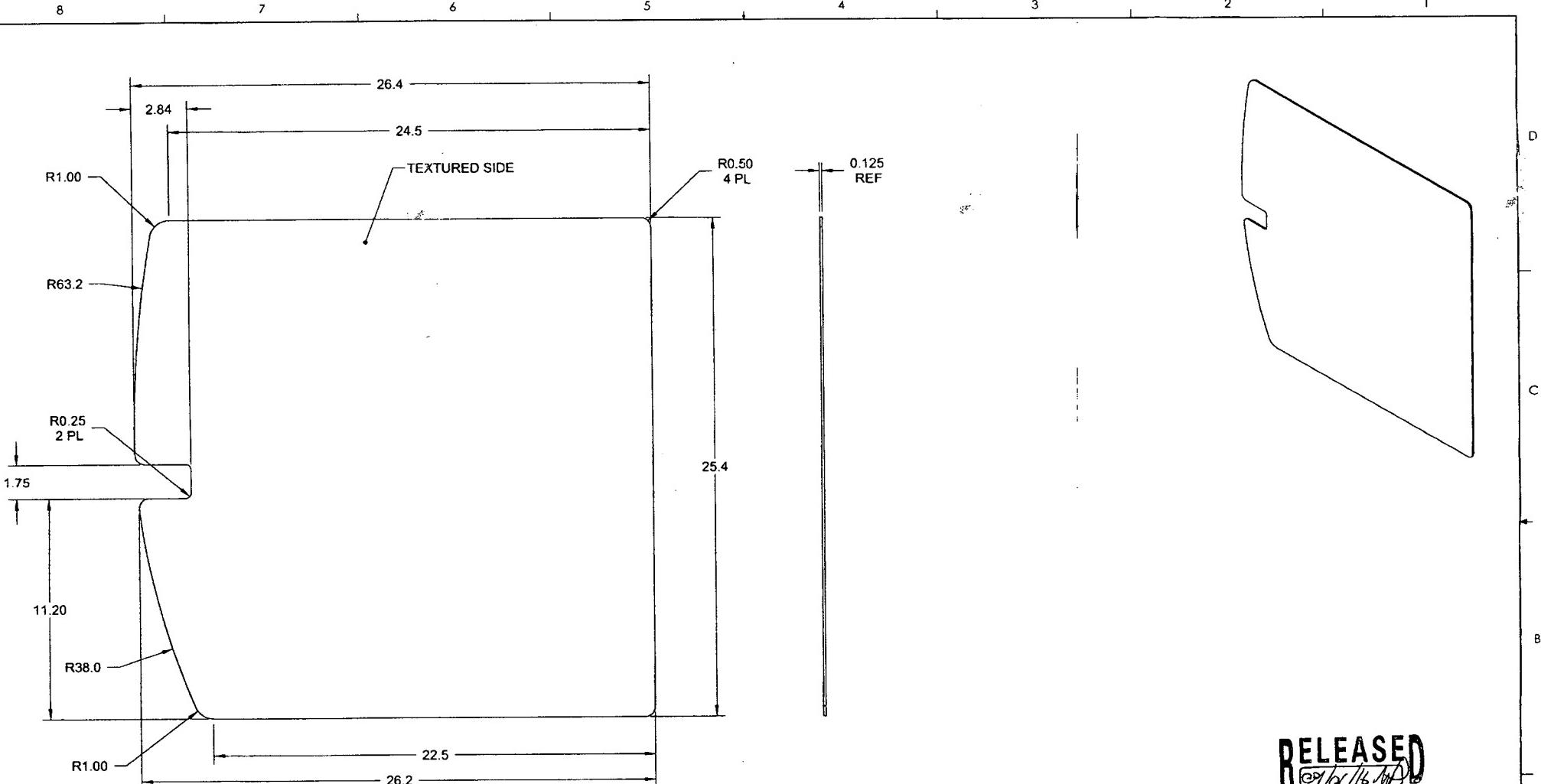
RELEASED
09/05/01

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3891-042" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 2.93 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

DESIGN	<i>90</i>	DART AEROSPACE LTD	
DRAWN	<i>90</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BT</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>BT</i>	D3891	SHEET 2 OF 6
APPROVED	<i>AM</i>	TITLE	SCALE
DE APPR.	<i>AM</i>	PANEL, FWD	
DATE	09.05.01	NTS	

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D3891-1 PANEL

NOTES:

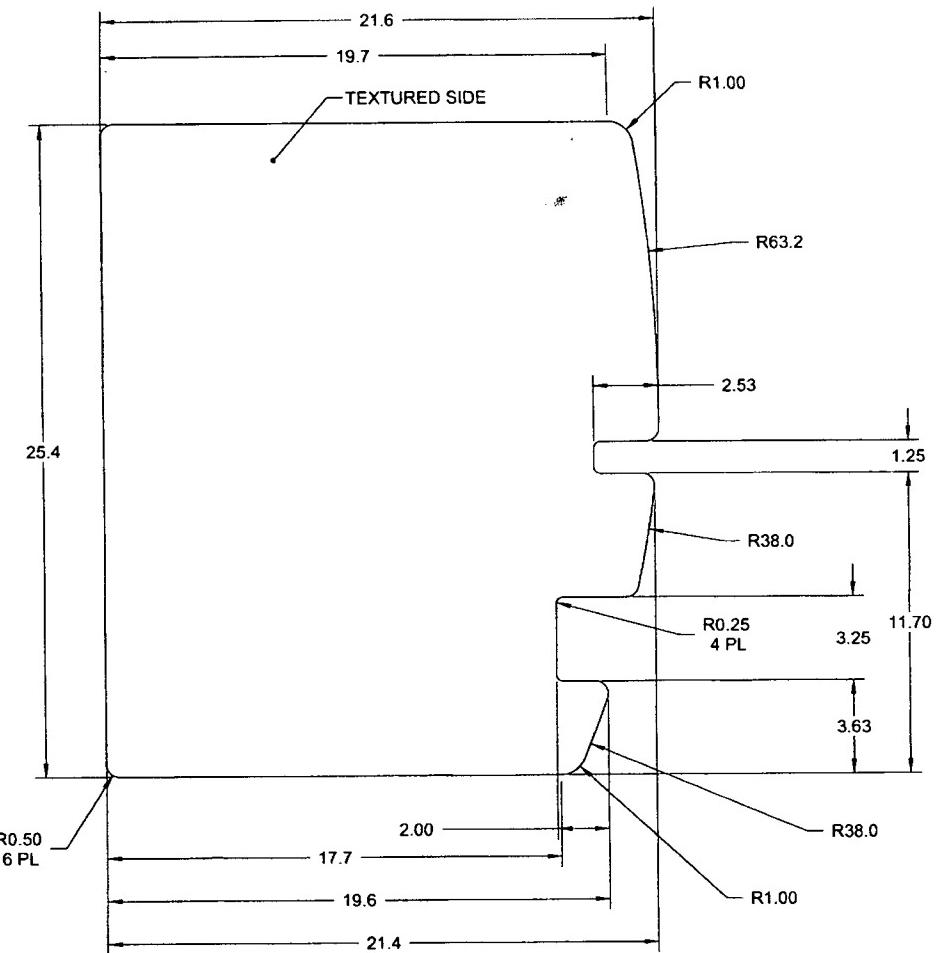
- 1) MATERIAL: F60029 GY3778 LEXAN SHEET (HEAVY HAIRCELL TEXTURE, DARK GREY), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC. MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.46 lbs

DESIGN	<i>DP</i>	DART AEROSPACE LTD	
DRAWN	<i>DP</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BH</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>SAC</i>	D3891	SHEET 3 OF 6
APPROVED	<i>SAC</i>	TITLE	SCALE
DE APPR.	<i>SAC</i>	PANEL, FWD	NTS
DATE	09.05.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

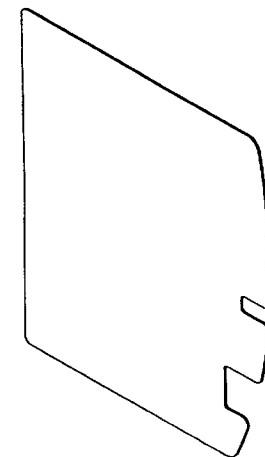
*RELEASED
07/07/04*

w/b 54690

8 7 6 5 4 3 2 1



0.125
REF



D3891-2 PANEL

NOTES:

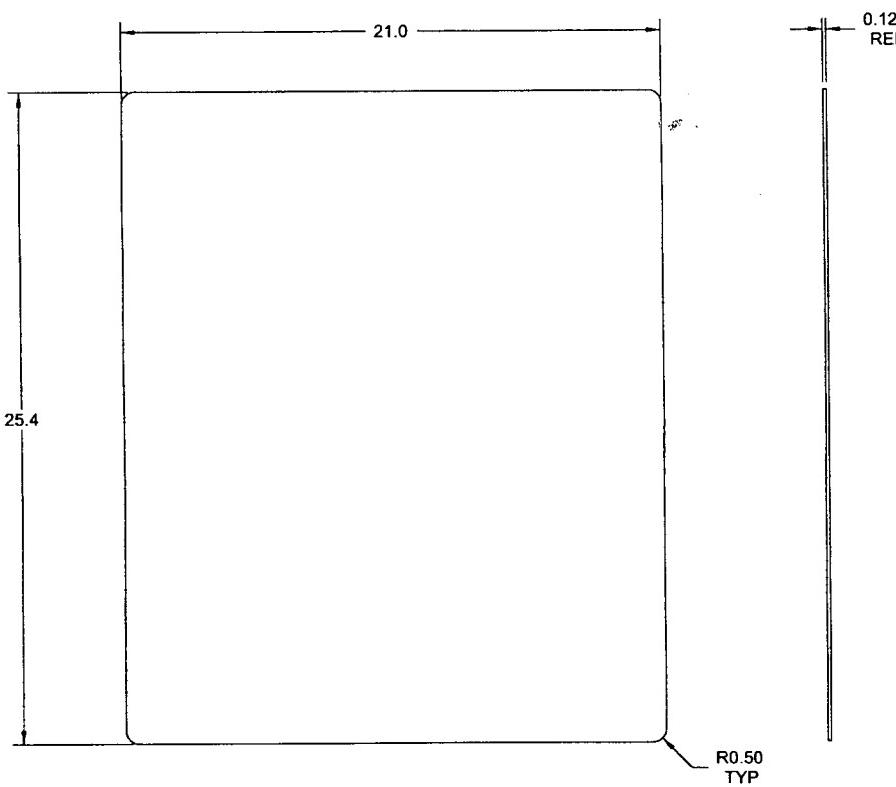
- 1) MATERIAL: F60029 GY3778 LEXAN SHEET (HEAVY HAIRCELL TEXTURE, DARK GREY), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC. MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.77 lbs

8 7 6 5 4 3 2 1

DESIGN	90	DART AEROSPACE LTD	
DRAWN	00	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AB	DRAWING NO.	REV. A
MFG. APPR.	SMP	D3891	SHEET 4 OF 6
APPROVED	MW	TITLE	SCALE
DE APPR.	-	PANEL, FWD	NTS
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W6 54690
RELEASED
09/05/10 14:00

8 7 6 5 4 3 2 1



D3891-3 GASKET

RELEASED
09/06/01

w/o 54690

NOTES:

- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK
(REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.21 lbs

DESIGN	99	DART AEROSPACE LTD	
DRAWN	99	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PT	DRAWING NO. REV. A	
MFG. APPR.		D3891 SHEET 5 OF 6	
APPROVED		TITLE SCALE	
DE APPR.		PANEL, FWD NTS	
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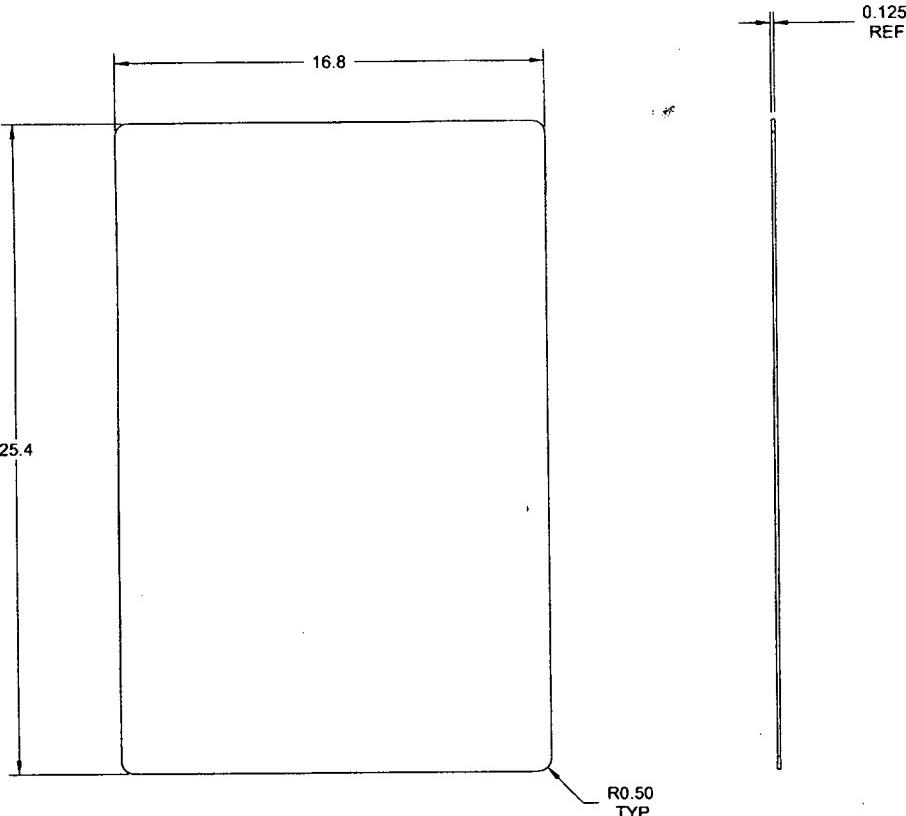
D

C

B

A

8 7 6 5 4 3 2 1



D3891-4 GASKET

RELEASED
09/08/16-AB

W 10 54690

NOTES:

1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK
(REF DART SPEC. M4111N-S.125)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: NONE

6) IDENTIFICATION: NONE

7) WEIGHT: 0.17 lbs

DESIGN	Q	DART AEROSPACE LTD	
DRAWN	Q	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Q	DRAWING NO.	REV. A
MFG. APPR.	Q	D3891	SHEET 6 OF 6
APPROVED	Q	TITLE	SCALE
DE APPR.	Q	PANEL, FWD	NTS
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8 7 6 5 4 3 2 1

DART AEROSPACE LTD	Work Order:	54690
Description: Gasket	Part Number:	D3891-4
Inspection Dwg: D3891 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	B	Audited by:	G	Prototype Approval:	N/A
Date:	9-12-16	Date:	9/12/16	Date:	N/A
Rev	Date	Change		Revised by	Approved
A	09.07.29	New Issue		KJ	